

Work Order ID 51778

Thursday, September 03, 2009 8:12:12 AM

Page 1

Item ID: D135-751-011

Accept

Revision ID: C

Item Name: Skidtube Installation

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/17/2009 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3507

Rev C

0.00

100



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

0.00

110



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

9-9-14

Work Order ID 51778

Page 2

Thursday, September 03, 2009 8:12:12 AM

Item ID: D135-751-011

Accept



Setup Start



Revision ID: C

Stop



Item Name: Skidtube Installation

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



CNC Bend 1

BENDING MACHINE - SKIDTUBES

0.00

CNC Delta 100 Bender

Memo

- Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".

- cut Fwd End of Tube As per dwg D3507

DP
9-9-14

Work Order ID 51778

Thursday, September 03, 2009 8:12:12 AM



Page 3

Item ID: D135-751-011
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Setup Start



Stop



Start Date: 9/3/2009 Start Qty: 1.00
Required Date: 9/17/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Cut Fwd end of the tube using DT8185- HA								
	2-Cut Aft end at VC using DT8185 <i>as per dwg D3507</i>								
	3-Debur ends								
	4-Drill Aft & Fwd Cap holes using DT8678 & DT8901								
	5-Locate DT8870 & Drill Ground wire hole on top of Tube.								
	6-Locate DT8870 with 3/16 ^{#30} Cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using 3/16 ^{#30} drill. ****DO NOT OPEN AFT CAP HOLES****								
	7-Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.								
	8-Open six rear wearplate holes using DT8892. Open holes to 0.297"								
	9- Section G-G holes must be laid out manually, open to #30.								
	10- Drill holes section G-G (DT9431)								
	11-Open Aft & Fwd Cap holes using .208" drill.								
	12-Bore out aft end of tube as per Dwg D3507 & Detail "B".								
	13-Open ground wire hole .297" section E-E								

9-9-14

Work Order ID 51778

Thursday, September 03, 2009 8:12:12 AM

Page 4

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

14-Deburr holes.

DP 9-9-14

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

2) S. S. S. S. S.

TL

P

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1 0.00

Memo

0.00

M

09

09

16

(1)

Work Order ID 51778

Page 5

Thursday, September 03, 2009 8:12:12 AM

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Setup Start



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Cust Item ID:

Required Date: 9/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Am 09 - 09 - 160

Work Order ID 51778

Thursday, September 03, 2009 8:12:12 AM

Page 6

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Customer:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507.
and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: M112391Exp Date: 2/20/2010

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D

A/R AL ROD

Batch: m111999

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

DP
9-9-17

DP 9-10-6

DP 9-10-6

Work Order ID 51778

Thursday, September 03, 2009 8:12:12 AM

Page 7

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Reference:

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




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	2) 502/10/06						
190  Skidtubes Skidtubes	Skidtubes Memo 1-Rivet D3506-1/-3 as per Dwg D3507.	0.00 0.00	DP 9-10-8						
200  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	2) 502/10/06						

Work Order ID 51778

Thursday, September 03, 2009 8:12:12 AM

Page 8

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Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

7/11 09/10/09

Memo

0.00

(K)

S

220



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 109091

BL 09-10-9

Memo

0.00

START TIME: 10:25

OVEN TEMPERATURE: 320°

FINISH TIME: 10:55

(D)

230



QC

Quality Control

QC3- Inspect Part Finish

0.00

all 09/10/15

Memo

0.00

(K) S

Work Order ID 51778

Thursday, September 03, 2009 8:12:12 AM

Page 9

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240



HandFinish

Hand Finishing

HandFinishing

Memo

Install Wearplate & Ground Wire inserts as per Dwg D3507.

0.00

0.00

BR 09-10-13 - ①

250



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Inspect Inserts

0.00

0.00

1

09-10-16

Work Order ID 51778

Thursday, September 03, 2009 8:12:12 AM



Page 10

Item ID: D135-751-011

Accept



Setup Start



Revision ID: C

Stop



Item Name: Skidtube Installation

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: M112391

Exp Date: 10/20

3-Install Wearplates as per Dwg D3507 ,

Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube

Do not Install Scews where indicated on Dwg(Note #6)

A/R 241 Sika Flex Batch: M112391

Exp Date: 10/20

4-Install Plug assemblys as per Dwg D3507.

5- Wing Walk as per Dwg D3507 and QSI 005 4.4 M112106

270



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) 801/10/14

bl 09-10-14. ①

② P

Thursday, September 03, 2009 8:12:12 AM

Accept

**Setup Start**

Abstract

Stop

[illegible]**Cust Item ID:**[illegible]

Required Date: 9/17/2009 **Req'd Qty:** 1.00

Customer:

Reference:

Run Start

[illegible]

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

RESEARCH DESIGN AND METHODS

0.00

Packaging



0,00

Quality Control

0.00

Identify and pack for shipping as per PPP D135-751-011

Location:

PPP Rev: 15

Work Order ID 51778

Thursday, September 03, 2009 8:12:13 AM

Page 12

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Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/17/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

310

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/16/19 *[Signature]*
PL 09-10-14

Picklist Print

Thursday, September 03, 2009 8:12:24 AM

Page 1

13

Work Order ID: 51778



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 9/3/2009

Required Date: 9/17/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2962-150RevA		Manufactured	No			110	Each	43.0000	1.0000			
3.540 Outer Tube, Extrut												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43

43

28672

D3504-1RevC

Manufactured No



Crossbolt Spacer

170

Each

15.0000

2.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

15

15

31234

D3504-3RevC

Manufactured No



Crossbolt Spacer

170

Each

16.0000

1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

16

16

31232

DP 9-9-15

2 SE 09/09/06

1 SE 09/09/06

Picklist Print

Page 2

Thursday, September 03, 2009 8:12:24 AM

Work Order ID: 51778

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation


Comments:

Start Date: 9/3/2009

Required Date: 9/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3504-5RevC  Crossbolt Spacer		Manufactured	No			170	Each	10.0000	2.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

10

36181

10

D3505-1RevA

Manufactured No



Web

170

Each

2.0000

1.0000



2 BE 09/09/09

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

2

51708

2

D3506-3RevA

Manufactured No



Doubler

170

Each

14.0000

2.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG

14

50563

14

9-10-8

2

Thursday, September 03, 2009 8:12:24 AM

Shop Packet Print

Page 2

Picklist Print

Page 3

Thursday, September 03, 2009 8:12:24 AM

Work Order ID: 51778



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 9/3/2009

Required Date: 9/17/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			240	Each	3,406.000	38.0000			
Insert												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3406

105855

16

108606

52

111529

1488

111779 ✓

1850

MS20601-AD4W3

Purchased

No



Rivet

240

Each

270.0000

12.0000



38. BK 09-10-14

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

270

107823

3

111359

267

DP 9-10-08

12

Picklist Print

Page 4

Thursday, September 03, 2009 8:12:24 AM

Work Order ID: 51778

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:

Start Date: 9/3/2009

Required Date: 9/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			260	Each	8,785.000	1.0000			
Insert												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8785

107441

16

110768 ✓

8769

260

Each

210.0000

31.0000

AN3C4A

Purchased

No

BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

-44

112314

-44

Main Warehouse

ST

254

112082

14

112314

240

112720

31 BR 09-10-14

Thursday, September 03, 2009 8:12:24 AM

Shop Packet Print

Page 4

Picklist Print

Page 5

Thursday, September 03, 2009 8:12:24 AM

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Required Date: 9/17/2009

Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C5A 		Purchased	No			260	Each	646.0000	2.0000			
Bolt												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

646

111424

8

111707

338

112314 ✓

200

112489

100

2 *OK 09-10-14.*

AN526C1032R10

Purchased

No



Screw

260

Each

594.0000

2.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

594

108062 ✓

135

108167

35

110049

424

2 *OK 09-10-14.*

Thursday, September 03, 2009 8:12:24 AM

Shop Packet Print

Page 5

Picklist Print

Page 6

Thursday, September 03, 2009 8:12:24 AM

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			260	Each	2,500.000	33.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

FP

-44

112116

-44

Main Warehouse

ST

2444

112116

2444

D2965-3RevB

Manufactured

No



Cap

260

Each

6.0000

1.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

50560

6

Thursday, September 03, 2009 8:12:24 AM

Shop Packet Print

Page 6

33. BR 09-10-14.

1 BR 09-10-14.

Picklist Print

Page 7

Thursday, September 03, 2009 8:12:24 AM

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D2965RevB		Manufactured	No			260	Each	17.0000	1.0000			
												
Cap, 105 Skidtube												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP4

6

50609 ✓

2

50924

4

Main Warehouse

ST

11

43288

6

46800

5

D3492-041RevC

Manufactured

No



Plug Assembly

260

Each

3.0000

4.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

43816

3

D3492-043RevC

Manufactured

No



Plug Assembly

260

Each

0.0000

4.0000



51642

Thursday, September 03, 2009 8:12:24 AM

Shop Packet Print

Page 7

1 BR 09-10-14.

4 PR 09-10-14.

4 PR 09-10-14.

Picklist Print

Page 8

Thursday, September 03, 2009 8:12:24 AM

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D3492-047RevC		Manufactured	No			260	Each	56.0000	2.0000			
Plug Assembly												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

56

27776

1

28961 ✓

39

39722

16

D3508-1RevC Manufactured No



Wearplate

D3508-3RevC

Manufactured No



Wearplate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1

46881

1

D3508-5RevC Manufactured No



Wearplate

Thursday, September 03, 2009 8:12:24 AM

Shop Packet Print

Page 8

Picklist Print

Page 9

Thursday, September 03, 2009 8:12:24 AM

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Required Date: 9/17/2009

Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3508-7RevC 		Manufactured	No			260	Each	1.0000	1.0000			
Wearplate												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

51389

1

44518

1

1 9/10/14

D3558-1RevB



Manufactured

No

Gasket

260

Each

23.0000

1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

50925 ✓

23

23

1 9/10/14

D3558-3RevB



Manufactured

No

Gasket

260

Each

18.0000

1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45661 ✓

51391

18

6

12

1 9/10/14

Thursday, September 03, 2009 8:12:24 AM

Shop Packet Print

Page 9

Picklist Print

Page 10

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D3558-5RevB		Manufactured	No			260	Each	14.0000	1.0000			

Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

14

50926 ✓

14

D3558-7RevB

Manufactured

No



Gasket

260

Each

21.0000

1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

21

36388

2

43245

5

50927 ✓

14

NAS1611-007

Purchased

No



O-RING

260

Each

447.0000

1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

447

103697

447

N/A o-ring was
already installed
on the plug → older
batch of plug.

Thursday, September 03, 2009 8:12:24 AM

Shop Packet Print

Page 10

Picklist Print

Page 11

Thursday, September 03, 2009 8:12:24 AM

Work Order ID: 51778



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 9/3/2009

Required Date: 9/17/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1611-010		Purchased	No			260	Each	345.0000	1.0000			
O-RING												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

345

110715

50

110915 ✓

295

4.

BR 09-10-13

NAS1611-013

Purchased

No

260

Each

320.0000

1.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

320

106513

11

111424

109

111758 ✓

200

4

BR 09-10-13

Picklist Print

Page 12

Thursday, September 03, 2009 8:12:25 AM

Work Order ID: 51778



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 9/3/2009

Required Date: 9/17/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A BOLT		Purchased	No			280	Each	210.0000	8.0000			

m/12794 *9/14/12*

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

FP

-44

112314

-44

Main Warehouse

ST

254

112082

14

112314

240

AN960C10L

Purchased

No

280

Each

2,500.000

8.0000

washer

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

100

103585

100

Main Warehouse

FP

-44

112116

-44

Main Warehouse

ST

2444

112116

2444

m/1216

51778

Thursday, September 03, 2009 8:12:25 AM

Shop Packet Print

Page 12

Picklist Print

Page 13

Thursday, September 03, 2009 8:12:25 AM

Work Order ID: 51778



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 9/3/2009

Required Date: 9/17/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3506-1RevA		Manufactured	No			280	Each	3.0000	4.0000			

Doubler

9-10-8
B5189

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

46538

3

3

280

Each

3.0000

4

2.0000



B51380

(9/10/09) ①

D3512-1RevC

Manufactured No



Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST500

51133

3

3

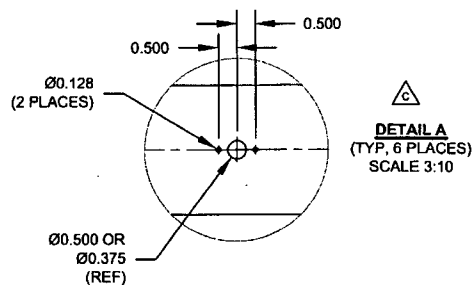
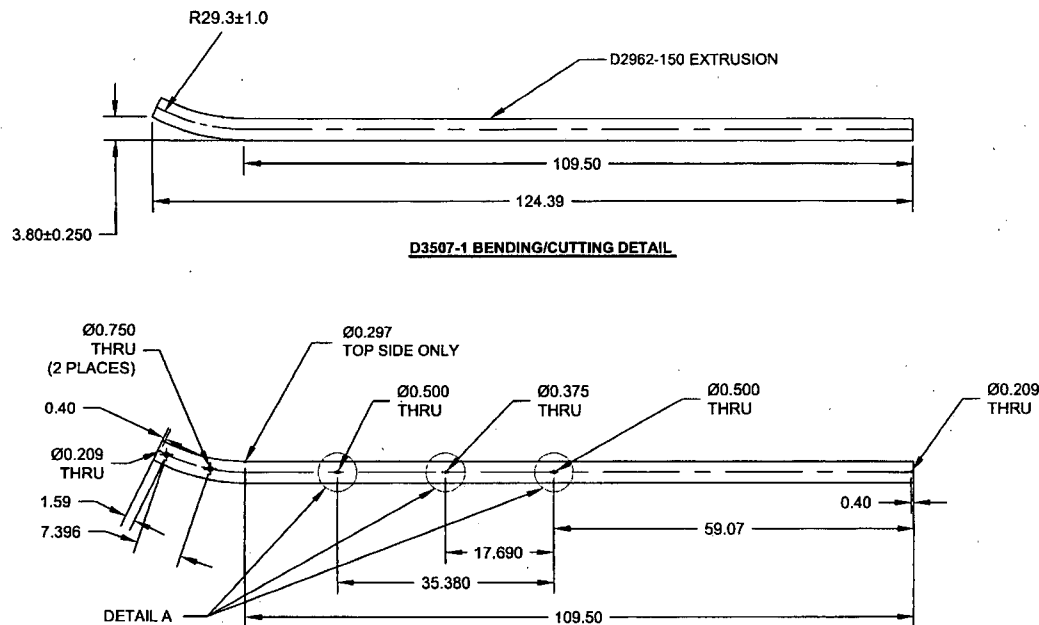
51778

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20801AD4W3	RIVET

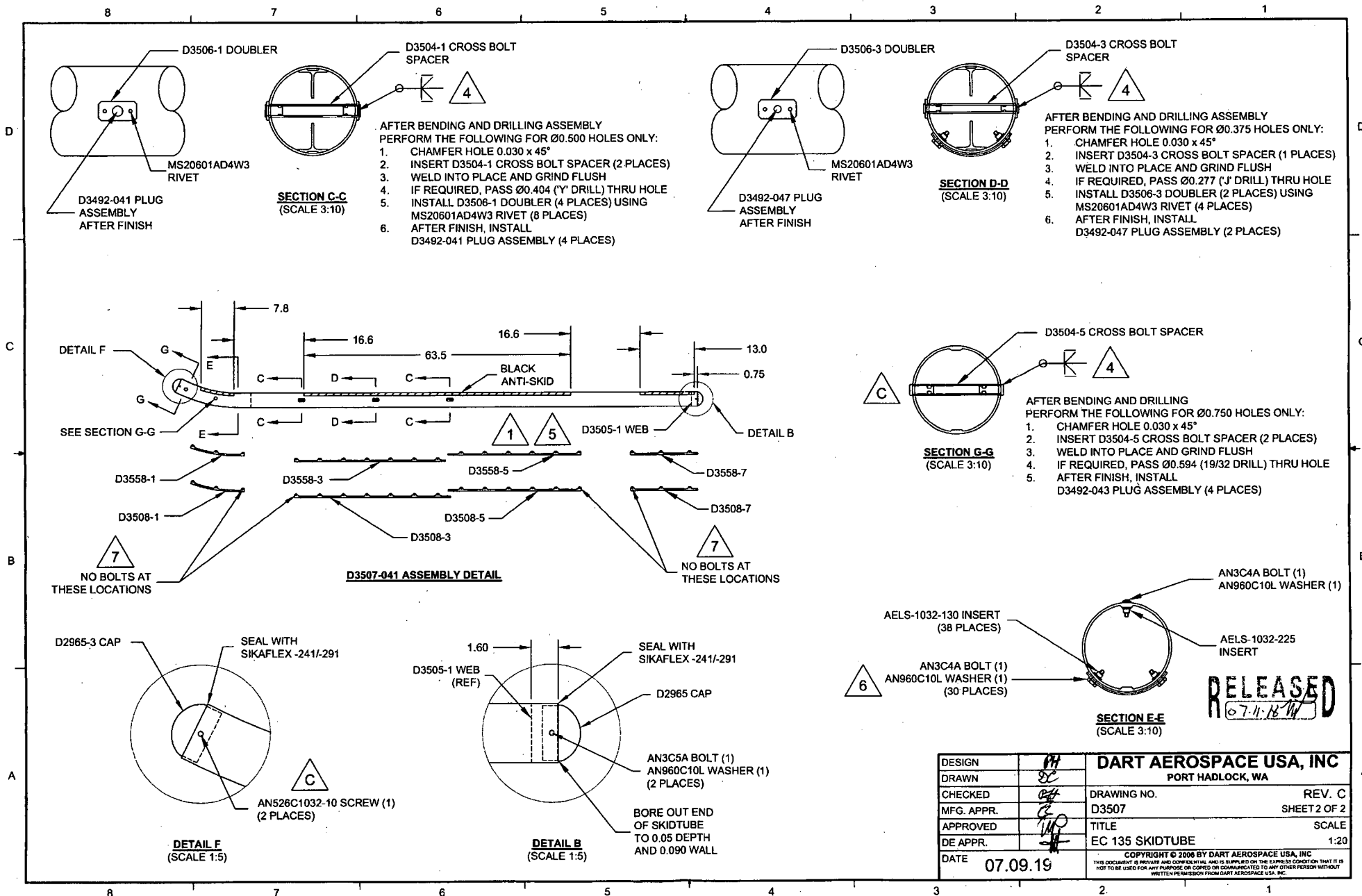
GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8888 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	JTC		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH	DRAWING NO.	REV. C
		D3507	SHEET 1 OF 2
		TITLE	SCALE
		EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



51778



NO. 204

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 505370
Part number: D135 751 011
Description: Skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:

pass ☒ fail ☐

Penetration:

pass ☒ fail ☐

UNACCEPTABLE

Cracks:

pass ☒ fail ☐

Undercut:

pass ☒ fail ☐

Pin holes:

pass ☒ fail ☐

Overlap (cold lap)

pass ☒ fail ☐

Porosity (surface):

pass ☒ fail ☐

Coloration:

pass ☒ fail ☐

Qualifier J. D. Dml

Date of Test Coupon 09-07-16

Welder Barclay Elliott

Date of Test Coupon 09/07/16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Material Requisitions

R/S#: _____

Part Number: AN3C6A

Batch Number: M111982

Quantity: 4

Required by: JA Date: 10 08 08

Used for _____

Part Number: ENG 1/00 June

Batch Number: _____

Approved by Purchaser: _____

Date: _____

Comments: _____

TRANS CA MATERIAL REQ-A.DOC

added to

51778 & 54168

D135-751-04

Each KIT

Requires

AN 3C 4A X 2

AN 3C 7A X 4 + 2

AN 4C 7A X 2

M114341
NAS 1149 C0332R X 6

AN 960C 416L X 2

M114382 X 2

DBS 751 011 B51778

DBS 751 101 B59468

DBS 751 011 B54168

DBS 751 101 B59468

Work Order Summary

June 9, 2010 9:48:52 AM

Page 1 of 1

Criteria : Work Order ID: eng1100june All Items All Product Families
 Work Order Start Dates 5/31/10 to 5/31/10 11:59:59 PM Work Order Required Dates 6/30/10 to 6/30/10
 11:59:59 PM
 All References
 Work Order Status Released

Work Order ID eng1100june Required Qty 1.0000 Status Code Released
 Item ID Accepted Qty 0.0000 Scrap Qty 0.0000
 Item Name
 Current Acct Value \$0.000 Sales Order ID
 Start Date 5/31/10 Required Date 6/30/10 Completed Date
 10:30:00 AM

Expense	** Actual **		** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each	Each
Material	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Labor	\$438.493	\$0.000	\$0.000	\$0.000	0.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$438.493	\$0.000	\$0.000	\$0.000	

Work Center Eng

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Total Amounts
armi01 <i>1 hr 40 min's</i>										
	6/07/10									
100			0.00	0.00	1.70	1.70	1.00	\$0.000	\$56.703	\$56.70
	6/08/10									
100			0.00	0.00	4.04	4.04	1.00	\$0.000	\$134.418	\$134.41
100			0.00	0.00	1.31	1.31	1.00	\$0.000	\$43.637	\$43.63
BELL01										
	6/01/10									
100			0.00	0.00	2.00	2.00	1.00	\$0.000	\$66.580	\$66.58
	6/02/10									
100			0.00	0.00	3.12	3.12	1.00	\$0.000	\$103.865	\$103.86
SHEP01										
	6/02/10									
100			0.00	0.00	1.00	1.00	1.00	\$0.000	\$33.290	\$33.29
Total:			0.00	0.00	13.17	13.17	6.00	\$0.000	\$438.493	\$438.49

L Lacelle

From: Bill Beckett [bbeckett@dartaero.com]
Sent: June 9, 2010 8:37 AM
To: 'L Lacelle'
Subject: RE: NEW PO 6883 FOR HAWKER PACIFIC PTY LTD - RF

Linda,
What were the approx costs associated with installing the extensions? What would the approx costs be to return the extensions and the skidtubes back to their original state?
Bill

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: June 9, 2010 8:18 AM
To: 'Bill Beckett'
Subject: FW: NEW PO 6883 FOR HAWKER PACIFIC PTY LTD - RF

fyi

From: Robbin Fraser [mailto:robbin@darths.com]
Sent: June 9, 2010 7:59 AM
To: Nancy MacLeod; sbedford@dartaero.com; llacelle@dartaero.com; mfauteux@dartaero.com
Cc: Linda Pilon
Subject: RE: NEW PO 6883 FOR HAWKER PACIFIC PTY LTD - RF

Hi Everyone,

Please hold this order until further notice. Hawker prematurely issued the PO and needs to confirm with the end user their requirement for it.

I hope to have an update in a day or two for you.
Sorry about that, Hawker sends their apologies too.

Regards,

Ms. Robbin Fraser

DART Helicopter Services, LLC

Tel: 1.613.632.3336
Toll Free (N. America): 1.800.556.4166
Fax: 613.632.4443
www.darthelicopterservices.com

From: Nancy MacLeod
Sent: June 8, 2010 9:37 AM
To: 'sbedford@dartaero.com'; 'llacelle@dartaero.com'; 'mfauteux@dartaero.com'
Cc: Shirley Hay; Linda Pilon; Robbin Fraser
Subject: NEW PO 6883 FOR HAWKER PACIFIC PTY LTD - RF

Please see the attached PO for Hawker Pacific Pty Ltd. _

6/09/10